

Date: Monday, 9/10/2007 1:28:54 PM
User: Kim Johnston

Process Sheet

40

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT MAINTENANCE STEP
Job Number	: 34496		
Estimate Number	: 12455		
P.O. Number	: N/A	Part Number	: D350591133
This Issue	: 9/10/2007 S.O. No. : N/A	Drawing Number	: D2946 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: REV. B
Previous Run	: 33954	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 10/5/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>[Signature] 07.09.11</u>		
Comment	: Est Rev: B 05.10.14 Modified step 10 KJ/EC Est Rev: B 06.07.19 D2946 @ rev.b EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 07.09.12

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-133 CHG002

Er 07.10.12

2.0 D2622120C Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
.500 D2622-120C Extrusion B34016

a.m 07.09.13

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

a.m 07.09.13

2-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

a.m 07.09.13

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er - 07.09.12 (4)

5.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2734 End Plate B33841

Er 07.10.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2944

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2944

Support

334004

KE 07-10-11

4

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and Bevel ends for welding

2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946

A/R Aluminum Rod M103798
M105058

3-Grind End Cap welds flush

A.M. 07.10.15

4

KE 07-10-11

4

KE 07-10-11

4

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD 07-10-15 (4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

KE 07-10-15

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M. 07.10.15

(4)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

KE 07-10-16

4

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

A/R AL ROD BATCH: M103794

A.M. 07.10.16 (4)

KE 07-10-16

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 34496

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-17 (4)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/17 x9

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Touch Up Chemical conversion

112

07-10-18

(4)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powdgr Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M/105068

m-1 07/10/18

(4X)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Wing Walk as per Dwg D2946 and QSI 005 4.4

m 105624

Fol 07/10/18 (4)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

07/10/18 (4)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

20.0

D22301

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)
Mounting Lug
Batch: 32163 1325553

12

7/10/18 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: AFT MAINTENACE STEP

Job Number: 34496

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Mounting Lug

Batch: 1534587

SP

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2606 f(s)/Unit Total : 5.0425 f(s)

Abrasion Strip 7.20" long x2

Batch: 1534293

SP

23.0

D2945

Step Mounting Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Step Mounting Plate

Batch: 1529914

SP

7/10/19 SP

24.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: M14855

M102140

SP

25.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M102280

SP

26.0

AN414A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Batch: M14600

M102473

SP

27.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 56.0000 Each(s)

Washer

Batch: M103338

7/10/18 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 8/1/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 34496

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS21042L4

Nut



Comment: Qty.: 14.0000 Each(s)/Unit Total : 56.0000 Each(s)

Nut

Batch: M104683

7/10/18

(X) SP

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SP 07/10/22

(X)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location:

PPP Rev:

PPR RLU D

6/7/01/2024

31.0

QC21

FINAL INSPECTION/W/O RELEASE.



Comment: FINAL INSPECTION/W/O RELEASE

(4)
07/10/23

Job Completion



U 07-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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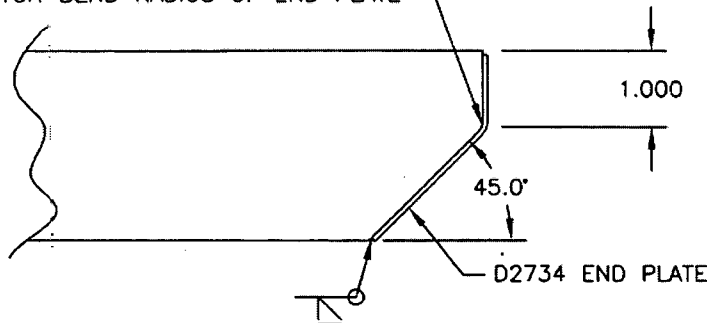
D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

*cut per drawing

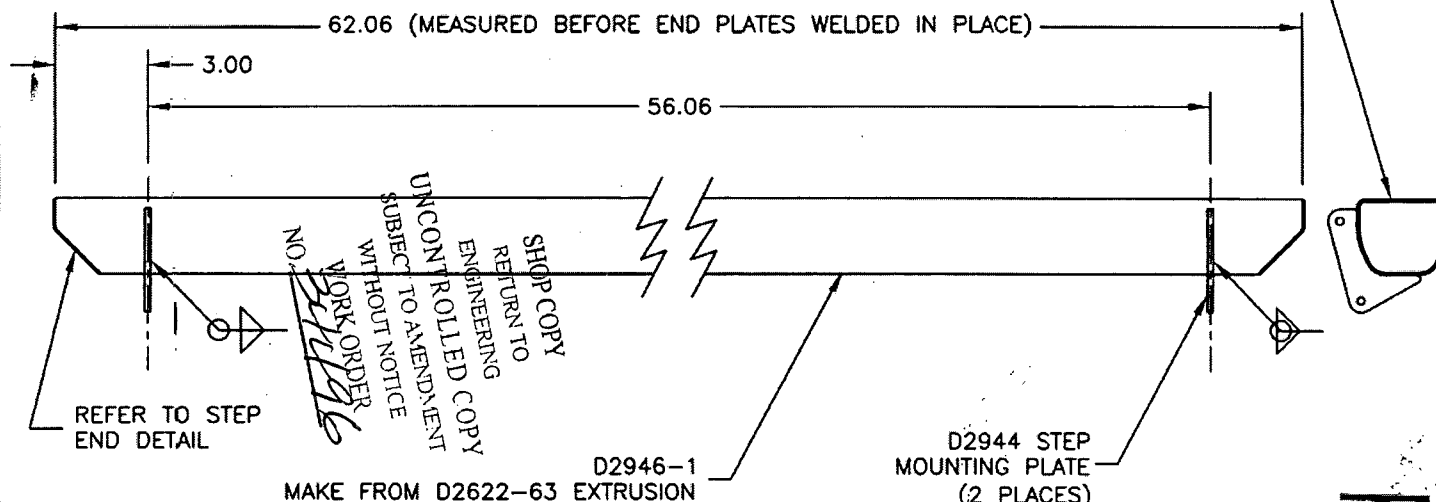
NOTE: ALL WELDS SHALL BE
100% VISUALLY
INSPECTED BY A
QUALIFIED INSPECTOR
PER DART QSI 004

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	CP	DRAWN BY	PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2946
DATE	05.11.14			TITLE STEP ASSEMBLY
				SCALE 1:6
				REV. B
				SHEET 1 OF 1
				NEW ISSUE
				UPDATE FINISHING NOTE
				05.11.29

RELEASED